

ASAP

Dart Aerospace Ltd.

Date: Thursday, 14/08/2008 3:47:45 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : DOUBLER
 Job Number : 41251
 Estimate Number : 13549
 P.O. Number :
 This Issue : 14/08/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run :
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 08-08-14 JLM Verified By:EC

Part Number : D32341
 Drawing Number : D3234 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 21/08/2008 Qty: 4 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.6080 sf(s)/Unit Total : 2.4318 sf(s)

2024-T3 .050 sheet

BATCH: 107711 HB 8-8-15

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3234

Dwg Rev: A

Prog Rev: A

HB 8-8-15

③

2-Deburr if necessary

HB 8-8-15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-8-15

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08-08-19 ③

P70

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-08-19 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 14/08/2008 3:47:45 PM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 41251

Part Number: D32341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 176

8/8/20

(34)

SW

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/2008

Job Completion

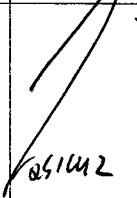


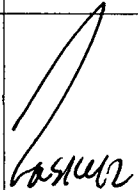
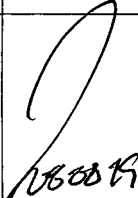


u 08.08.20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

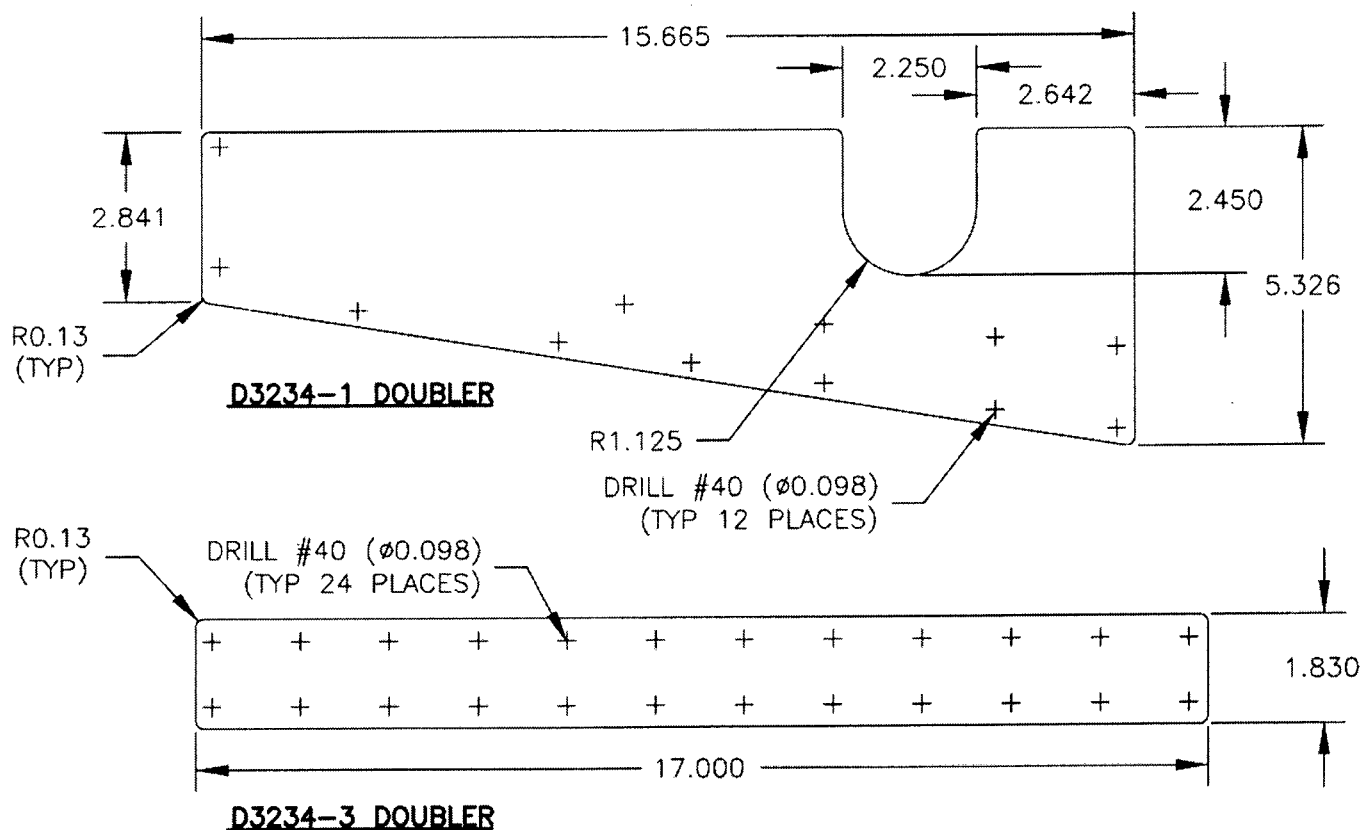
Part No: D3234-1 PAR #: 08-029 Fault Category: Prod Eng / Design NCR: ☒ Yes ☐ No DQA: D Date: 08/08/28
QA: N/C Closed: D Date: 08/08/28

NCR: 41251		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.08.19	4.0	No hole dimensions on the drawing to specify the pitch & location. R.C. holes are transfer drilled into the A/C per DS1 9269-011	 DS1/42	- Parts are acceptable as per dwg, & DS1 instructions. - PAR 08-029	N/A 	 08.08.19	 DS1/42	 08.08.19

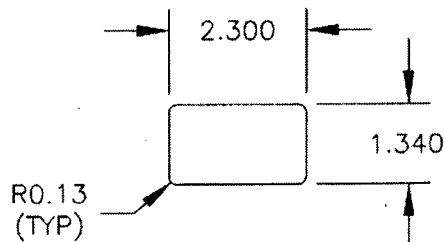
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3234	REV. A SHEET 1 OF 1
DATE 03.11.19	TITLE DOUBLER		SCALE 1:3
A	03.11.19	NEW ISSUE	



RELEASED
03.11.24



D3234-5 SPACER

D3234-1/-3 DOUBLER. D3234-5 SPACER

- 1) MACHINE PARTS PER DWG FILE "D3234-A.DWG"
- 2) MATERIAL: -1/-3: 2024-T3 (QQ-A-250/4), 0.050 THICK (REF DART SPEC. M2024T3S.050)
-5: 5052-H32 (QQ-A-250/8), 0.050 THICK (REF DART SPEC. M5052H32S.050)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES

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